

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024377**Date Inspected:** 06-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Liu Hua Jie/Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing:-

OBG Trial Assembly

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as 13BE Vertical Stiffeners and Edge Beam. The weld designation reviewed is as follows:

SEG3009S-008,032

SEG3009V-032

OBE13AD-017,018,019,020,021,022

In process Inspection:-

OBG Trial Assembly

This QA inspector observed the following work in progress:

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SMAW welding of weld joint No: VP3007-001-062 located on OBG Segment 13CE Vertical panel stiffener. Welder is identified as #037723. ZPMC QC is identified as Mr. Wang Li Yang. Welding was performed according to the weld repair report B-WR-21158. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G(1F)-FCM-Repair-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint No: OBE13-002 located on OBG Segment 13AE and 13BE Bottom panel Splice. Welder is identified as #043661. ZPMC QC is identified as Mr. Wang Li yang. Welding was performed according to the Critical weld repair report B-CWR-2992 Rev;2. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G(4F)-FCM-Repair-1.

This QA inspector observed the following work in progress:

FCAW welding of weld joint No: SEG3009K-118 located on OBG Segment 13BE Longitudinal Diaphragm to Bottom Panel. Welder is identified as #052696. ZPMC QC is identified as Mr. Zhong Yong Gang. Welding was performed according to the weld repair report B-WR-21109. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G(2F)-ESAB-Repair.

This QA Inspector observed the following work in progress:

SMAW in the 2F position for the OBG Segment 13BE Architectural Housing Assembly. The weld joint was designated as: SA3013-444/445. The welder is identified as #068924. ZPMC QC is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appear to comply with WPS-B-P-2112-FCM-1.

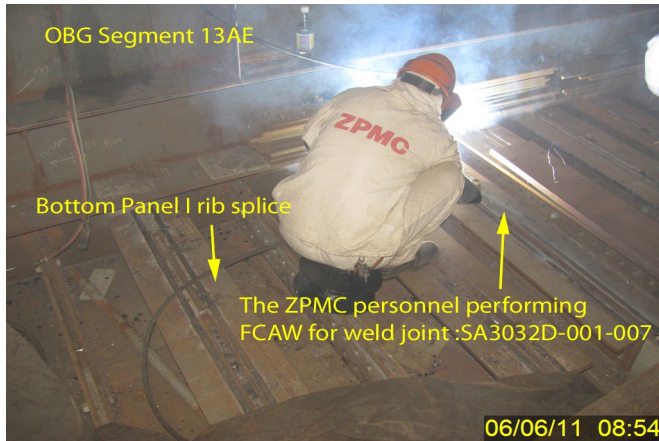
This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG Segment 13AE Bottom Panel I rib splice. The weld joint was designated as: SA3032D-001-007. The welder is identified as #055564. ZPMC CWI is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2231-ESAB. Please see the attached picture.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Pandaram

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer